

Work Order ID 101328-2

May-07-13 2:57:43 PM

Ship June 27

101328

Item ID: D4543-3

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 5/07/13

Start Qty: 15.00

15

Required Date: 5/30/13

Req'd Qty: 15.00

15

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLJ

Date: 13-05-08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4543

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Coole 1032

Memo

1- Cut as per dwg

Prog rev: B

Dwg rev: B

0.00

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

20

φ

Ac
13.06.20

21

φ

Ac
13.06.20

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101328

Page 2

Item ID: D4543-3

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 5/07/13 Start Qty: 15.00

Required Date: 5/30/13 Req'd Qty: 15.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(21)

13.06.24

DAS
09
9-89

130

0.00

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

S

13/06/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

13624

S

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101328

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Item ID: D4543-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer, LH

Start Date: 5/07/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

5 1613625

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

0.27
136.25

5

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

57528

143/026 (5)

Work Order ID 101328

May-07-13 2:57:43 PM

101328

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Item ID: D4543-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer, L.H

Start Date: 5/07/13

Start Qty: 15.00

15

Cust Item ID:

Required Date: 5/30/13

Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/6/27 *[Signature]*

13-06-24

Picklist Print

May 07-13 2:57:46 PM

Work Order ID: 101328

Parent Item: D4543-3

Parent Item Name: Retainer, Outer, LH

101328

D4543-3

Start Date: 5/07/13

Start Qty: 15.00

Required Date: 5/30/13

Required Qty: 15.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revA DD ver:EC IPP REV:C 13.04.23 as
per dwg revB DD ver:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

973.6200

1.144

18.06316

**

125822

25.30

13.06.20

M6061T6S 0.32

6061-T6 Sheet 0.032"

Location

MAT021

Loc Qty

973.62

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

51.85

123293

58.5

123483

260.6

123701

47.85

124629

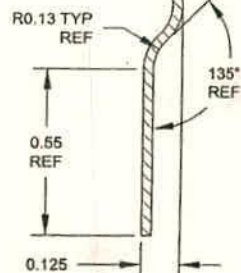
67.7

125341

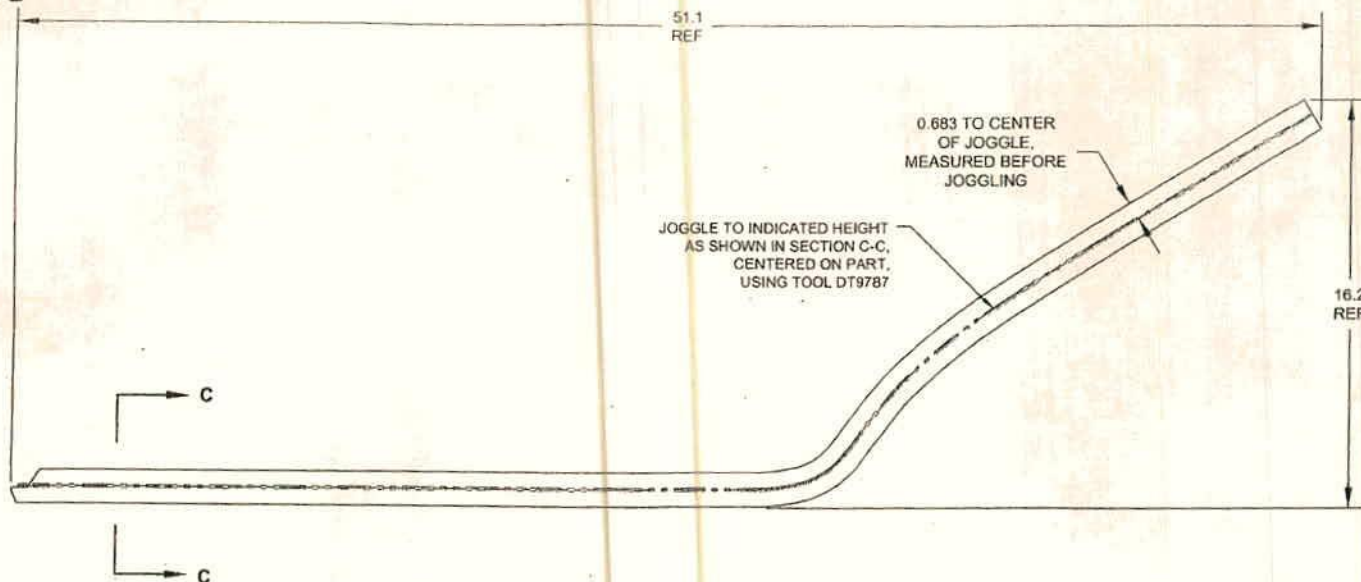
114

Loc Code

101328 MCT
1305-08



SECTION C-C
JOGGLE DETAIL
SCALE 12X



D4543-3 RETAINER, LH OUTER
(SIDE/TOP) B

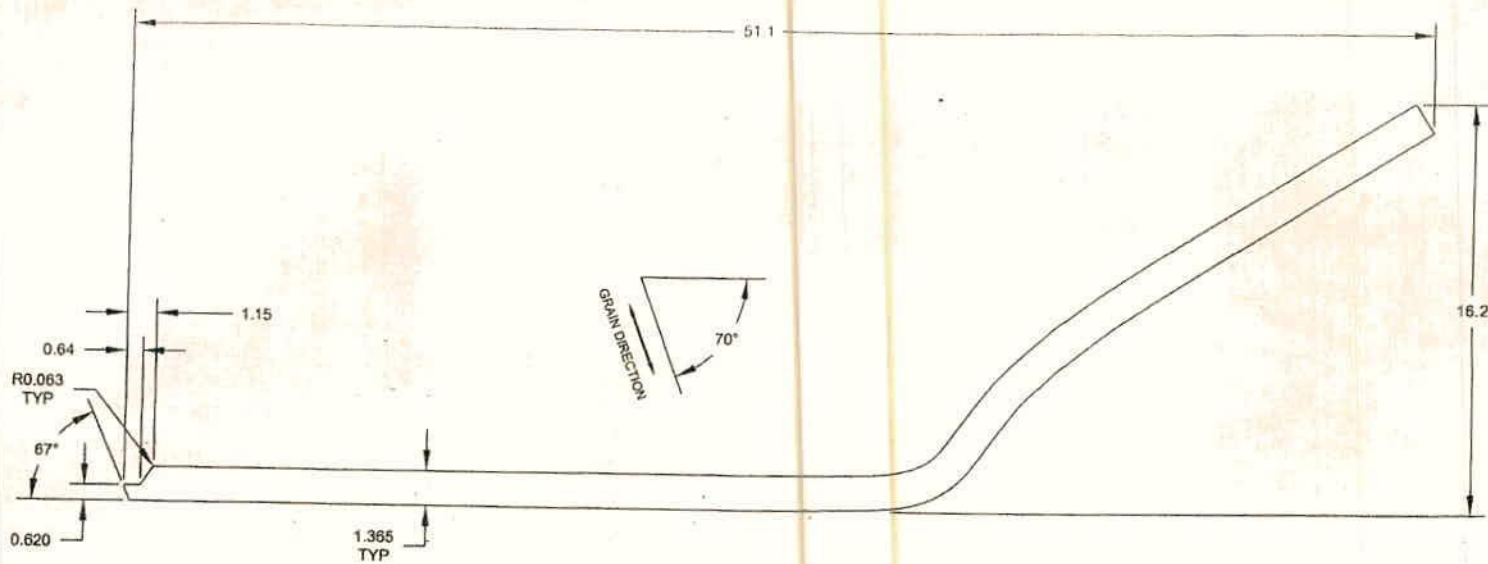
NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR IN ANY MANNER THAT MAY CAUSE HARM TO THE NATIONAL DEFENSE OF THE UNITED STATES OF AMERICA</small>	

RELEASED
2013-04-22

101300



D4543-3F FLAT PATTERN

B

RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 6 OF 9
APPROVED		TITLE	SCALE
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